

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007731**Date Inspected:** 03-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the corner assemblies of segments 2AE/2BE in response to Bolting Inspection Notification Sheet No. 00059:

Section 2AE, panel points 15~16, SP+SP T-rib flange splice on 3rd and 4th T-rib from the top:

ZPMC workers performed final bolt tightening verification at the direction of ZPMC QC Inspector Hu Mei Gang (QC1) using ZPMC calibrated wrench #X02-584. No less than 10% of the ASTM A325 bolt sets at each connection were torque tested, with a minimum of one bolt set tested at each connection. QC1 provided this QA Inspector, George Goulet, with the following information regarding the bolt sets installed at this location. This QA Inspector, George Goulet, observed ZPMC's Bolt Test Log for SFOBB (RoCap list), listing the RoCap Set numbers, bolt set size, and the N.M test result for torque tightening purposes. The information presented by QC1 and listed below appeared to this QA Inspector, George Goulet, to match the RoCap list.

RC Set No. DHGM220033 – M22-2.5x65 – test result 470N.M

The torque of the above noted bolt sets were verified by torque testing with the above noted calibrated wrench

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with the wrench setting displayed as above. This QA Inspector, George Goulet, concurred with QC1 for the issuance of green tag numbers.

This QA Inspector, George Goulet, also observed the following work in progress in the trial assembly area:

4BE/5AE joint – deck panel U-rib splice plate holes being aligned using taper pins.

4BE/5AE, panel points 28~29 – Two ZPMC welders applying overlay welds in the flat position with backing to the bottom 70mm of the south longitudinal diaphragm for the full length of the part. The part had previously been removed.

4BE/5AE, panel point 22~23 – north longitudinal diaphragm layed up after removal. No work being performed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above and QC1 informed this QA Inspector, George Goulet, of the above noted Ro Cap bolt set numbers, bolt set sizes, locations of installation, and previously tested torque values relevant to the inspection being performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
